

Work Order ID 65519

Wednesday, January 19, 2011 11:39:14 AM

DRAB GREEN



Page 1

Item ID: D2855

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 1/20/2011 Start Qty: 15.00



Cust Item ID:

Required Date: 2/3/2011 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 11-01-19

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2855

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13320 ☐ Cast per Dwg D2855 ☐ Material Release Note Required

CL

11/01/19

(15)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

11/01/31

(15)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Subtotal

(415)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65519

Wednesday, January 19, 2011 11:39:15 AM



Page 2

Item ID: D2855

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 1/20/2011 Start Qty: 15.00



Cust Item ID:

Required Date: 2/3/2011 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- Drill as per Dwg D2855 using DT8235 □2- Open holes to 19/64" □3- Deburr

⇒ m-l 11/02/07

15X

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sulorla

4.5

155



Drab Green(Ref:4.3.5.11)per QSI005 4.3 (Alum)

0.00

Powdercoat

Memo

0.00

Powder Coating

Start Time: 12:00
Temp: 320°F
Finish Time: 12:30

15X

m-l 11/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

▼NOTE: Date & initial all entries

Work Order ID 65519

Wednesday, January 19, 2011 11:39:15 AM

Page 3

Item ID: D2855

Accept

Revision ID:

Item Name: Cap

Start Date: 1/20/2011 Start Qty: 15.00

Required Date: 2/3/2011 Req'd Qty: 15.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

15 0 11/03/02

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

15 0 11/03/02

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 03 03 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

▼NOTE: Date & initial all entries

Work Order ID 65519

Wednesday, January 19, 2011 11:39:15 AM

Page 4

Item ID: D2855

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 1/20/2011 Start Qty: 15.00

Cust Item ID:

Required Date: 2/3/2011 Req'd Qty: 15.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: FP-7

0.00



Packaging

Memo

0.00

Packaging

XIS d JH 11/03/02

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/03 JF
MF
11-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, January 19, 2011 11:39:10 AM

Work Order ID: 65519

Parent Item: D2855

Parent Item Name: Cap



Start Date: 1/20/2011

Required Date: 2/3/2011

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP: B00.06.22 Added receiving step & removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	700.0000	2	30			
													
INSERT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST282		700							
				100896		100		M110768		X30			
				111529		300							
				111581		300							
D2855P		Purchased	No			170	Each	0.0000	1	15			
													
Cap													

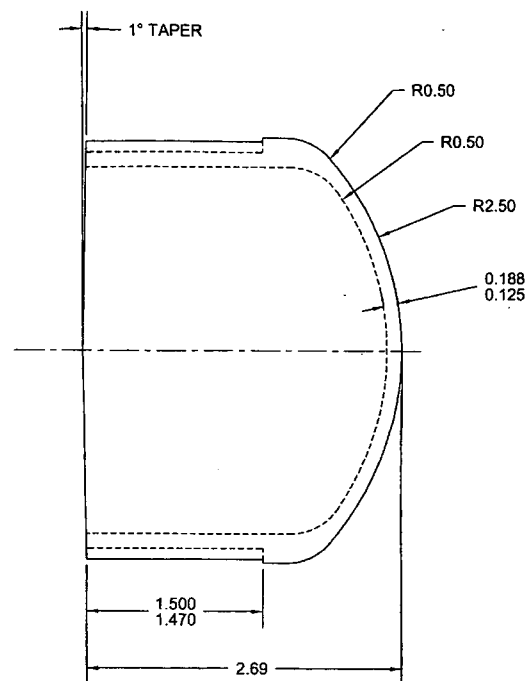
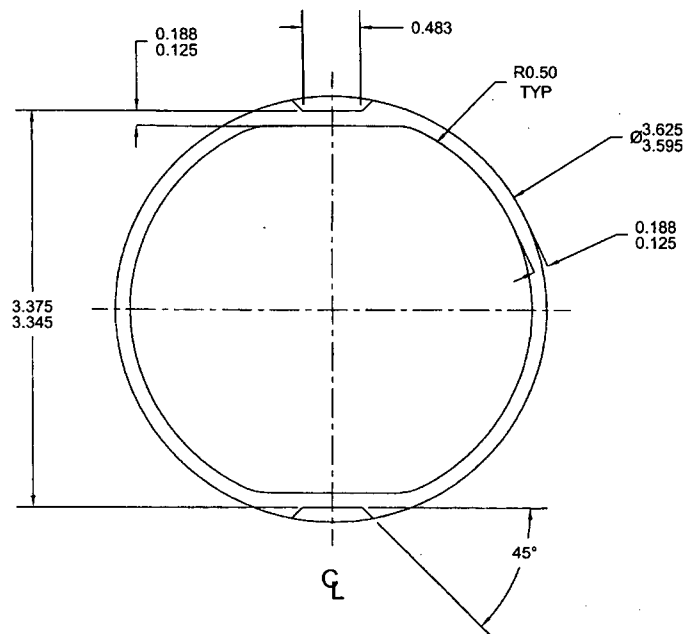
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

◆ NOTE: Date & initial all entries



D2855C CASTING DETAIL B

RELEASED
09/07/13 MJD

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D2855	SHEET 1 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

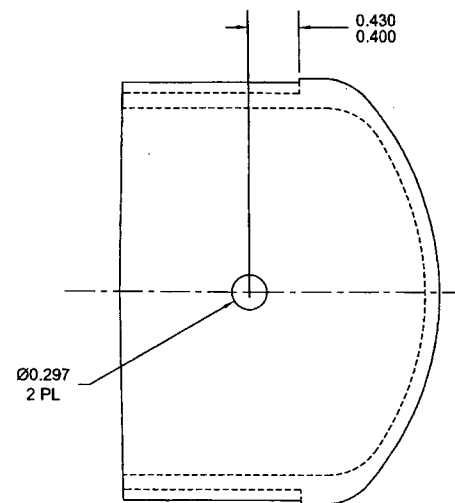
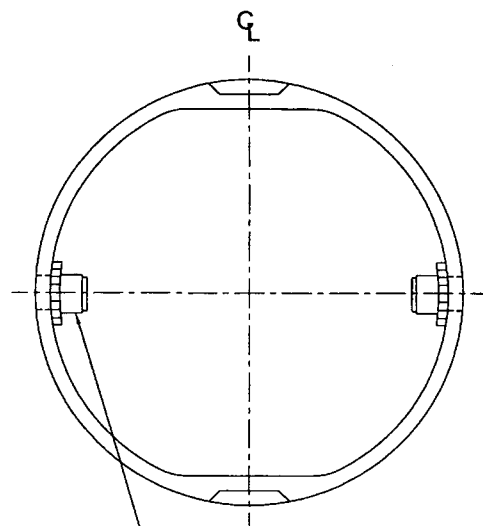
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)

#65519

RELEASED
31/07/15

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

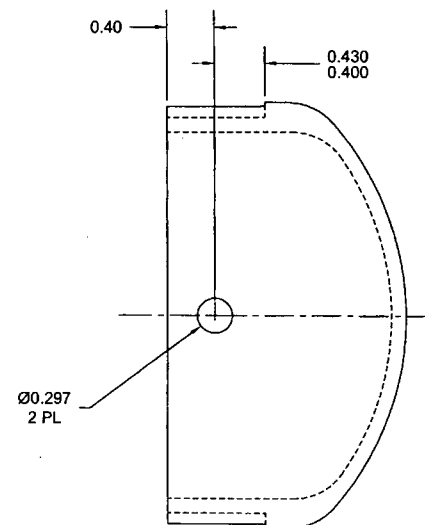
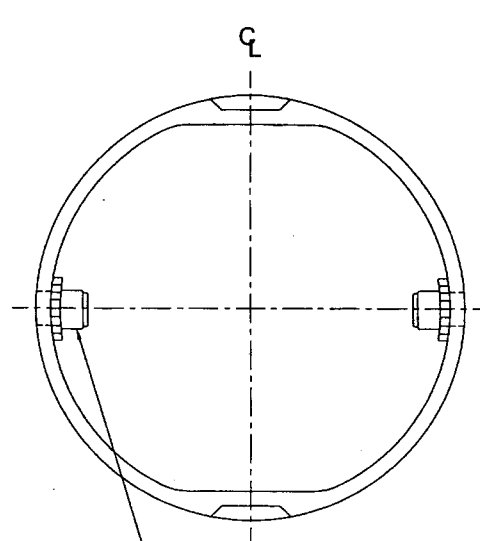
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL





D2855-3 CAP 
(MAKE FROM D2855C CASTING)

#65519

RELEASED
24/7/2013

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NT
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13320

Purchase Order Date 1/19/11

PO Print Date 1/19/11

Page Number 1 of 1

Order From : VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name

Vendor Phone 514 683 9777

Vendor Fax 514 683 0375

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

10127-2607

Net 30

CAD

Destination-Collect

REVISED

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FIXED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P	Cap	2/07/11 Yes	15.00 Each	FedEx PI collect	\$18.1000	\$271.50
		Special Inst:	AS PER DWG D2855 REV. A B65519 MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)				
2	D2855P	Cap	2/07/11 Yes	35.00 Each	FedEx PI collect	\$18.1000	\$633.50
		Special Inst:	AS ABOVE B65569				
PO Total:							\$905.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 3

Change Date: 1/19/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

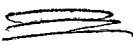
Aluminum Foundry Ltd

2225 Chemin St. Francois
Dorval, Québec H9P 1K3
Tel: (514) 683-9777
Fax: (514) 683-0375
email: info@foundryafpw.com

Packing Slip

Packing Slip No.: 33599
Shipped Date: 01 26 11

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 13320	
Shipped By: Fedex collect	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046 	Each	D2855 CAP REV.A 8/11/02/01 (413)	50 15
Received by:			
Date:			
Comment:			

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

2225 Chemin St. Francois, DORVAL, QC H9P-1K3
TEL : (514) 683-9777 FAX: (514) 683-0375

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W.Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **26/01/2011** Slip No. **33214**

Hawksbury, ON, K6A 1K7

Votre No. Commande **10794**
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
50pcs	D 2855 CAP <i>Silb201</i> <i>45 pcs</i>	<u>Z098046</u>	<u>A356.2</u>	Ingot#C6250541 B#11025001
Analyse Analysis (as in Ingot)				
(Si)	6.90%	(Al)	balance	
(Fe)	0.11%			
(Cu)	<0.01%			
(Mn)	<0.01%			
(Mg)	0.38%			
(Zn)	<0.01%			
(Ti)	0.11%			
Donne Yield :	Résistance a la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %		

Pour et au nom de
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Par/Per :

Coc-100